



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D205-634-145
Job Sheet 202255



Part No: D205-634-145

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 10/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2580-049 REV H, IIN-D205-634 REV I IPP REV:B 14.04.21 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/31/19		0.00	0.33	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		MCA
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	Skidtubes - Bend - 2 - B4B	1 pcs	10/31/19		0.00	2.00	Skidtubes - Bend - B4B		MCA
							Skidtubes - 1 - B4B		
130	Skidtubes - 2 - B4B	1 pcs	10/31/19		0.00	2.00	Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		MCA
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
140	QC 5	1 pcs	10/31/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		SE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Container No: S227439



Part: D205-634-145

Job No: 202255

Serial No/Batch: S227439

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3, FAA-STD SR005631

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10/23/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150 Skidtubes - 3 - B4B	1 pcs	10/31/19	0.00 1.00		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	MDA
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
160 QC 10	1 pcs	10/31/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 10 - 68	DAS NOV 04 2019 68
					QC 5 - 10	9-89
					QC 5 - 12	
170 QC 5	1 pcs	10/31/19	0.00 0.00		QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS NOV 04 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
180 Handfinish - 2-1 Pressure- B4B	1 pcs	10/31/19	0.00 0.50		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	NOV 04 2019
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
190 Powdercoat - 1 White GI(A)- B4B	1 pcs	10/31/19	0.00 1.00		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BE 19 11-5
					Powdercoat - 4 - B4B	
200 QC 3	1 pcs	10/31/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	11 19-10-07
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	

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					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210	Handfinish - 3-1- WingWalk- B4B	1 pcs	10/31/19	0.00 2.00	Handfinish - 3 - 1 - B4B	HL 14-11-05
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
220	QC 5	1 pcs	10/31/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS NOV 05 2019 40
					QC 5 - 61	9-89
					QC 5 - 81	
230	Packaging 3-1 - Stock - B4B	1 pcs	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	NL 6/11/19
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
235 DC - 1 - B4B	1 pcs	10/31/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	NOV 06 2019
240 QC 21 - FG	1 pcs	10/31/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	NOV 06 2019
				QC 21 - SA - 53	

Part Op 110 - (Skidtubes)1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL Descriptions: 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - (CNC Delta 100 Bender)1-Bend as per program D2580 SKID on CNC Bender and Folio FT 16 2-Cut tubes as per Dwg. D2580 3- Scribe batch# in aft end of tube

130 - (Skidtubes)1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Skidtubes)1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 13901 - Grind welds flush. 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

160 - (QC10- Inspect visual per QSI004- ground welds)

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)Realodine tube as per QSI 005

190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

200 - (QC3- Inspect Part Finish)

210 - (Assemble as per dwg)1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 _____ Sikaflex expire date: _____ 2-Coat D2594-3 O' rings with

220 - (QC5- Inspect part completeness to step on W/O)Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

230 - (Identify as per dwg & Stock Location: _____)Identify and pack for shipping as per PPPD205-634-145 Location : FG073

235 - (Document Control)Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

240 - (QC21- Final Inspection - Work Order Release)

Job BOM

012772

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - 1	S 209381
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	150-Skidtubes - 3 - B4B	3177095
D4202-1	Spacer	24 pcs (24 ea)	150-Skidtubes - 3 - B4B	S 104047
AN3-5A	Bolt	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5216385
AN4-45A	Bolt	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5192451
D2570	Bushing	16 pcs (16 ea)	210-Handfinish - 3-1- WingWalk-B4B	51941295-2
D2594-1	Plug	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	S 206811
D2594-3	O-Ring	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5045947
D2855	Cap	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5194521
D5061-1	Fwd Wearplate	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5140887
D5061-3	Aft Wearplate	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5203397
MS21042-4	Nut	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5089336
NAS1149D0332J	Washer	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5178378

Job Allocations

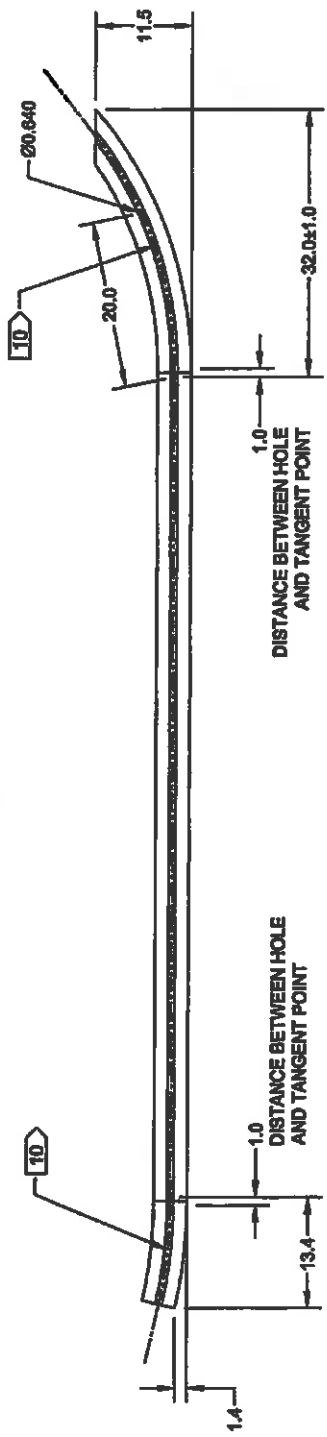
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2580-1	1	21	0
150-Skidtubes - 3 - B4B	D2576-3	1	70	0
	D4202-1	24	1,450	0
210-Handfinish - 3-1- WingWalk-B4B	AN3-5A	2	260	0
	AN4-45A	8	21	0
	D2570	16	193	0
	D2594-1	8	59	0
	D2594-3	8	466	0
	D2855	1	78	0
	D5061-1	1	9	0
	D5061-3	1	7	0
	MS21042-4	8	74	0
	NAS1149D0332J	2	1,516	0

Part Specifications

Specifications could not be found.

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1 2 3 4 5 6 7 8



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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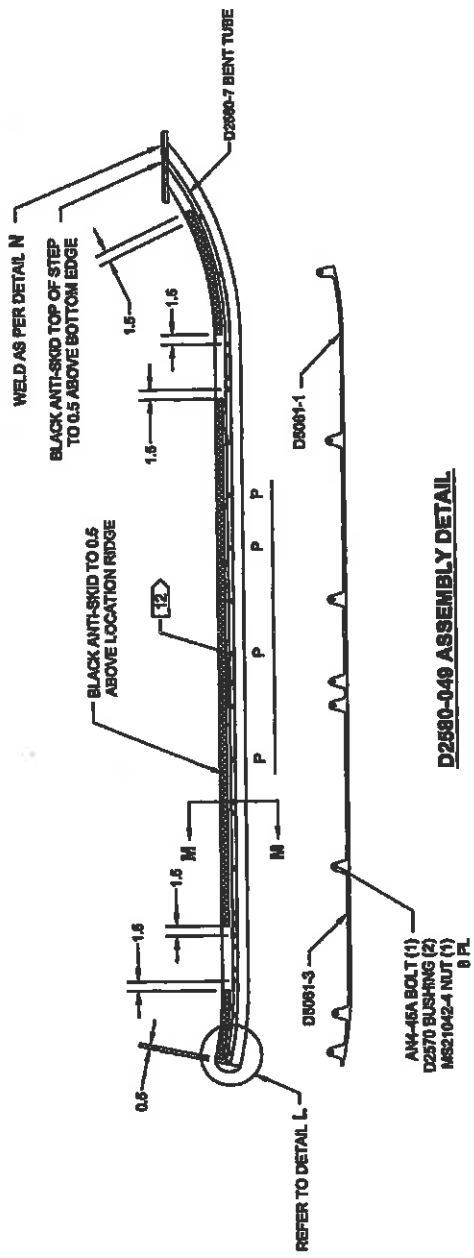
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DRAWN	SAD	HAWKSBURY, ONTARIO, CANADA
CHECKED	W	DRAWING NO.
INFO. APPR.	D2580	REV. H
APPROVED	#	SHEET 3 OF 9
DATE	17.06.09	SCALE
		206 SKIDTUBE ASSEMBLY
		NTS
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DEPARTMENT

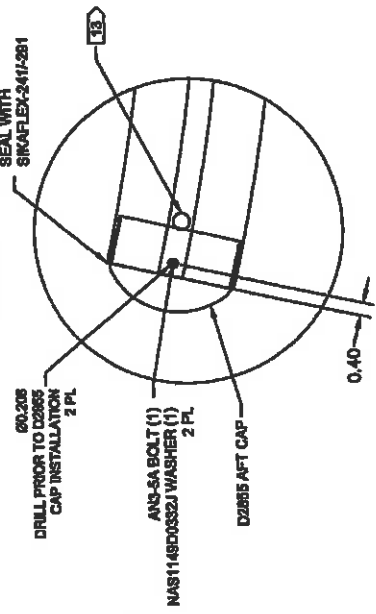
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DRAWN	SAD	DRAWING NO.	REV. H
CHECKED	<i>[Signature]</i>	D2580	SHEET 8 OF 9
MFG. APRR	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DE APRR	<i>[Signature]</i>	CONFIDENTIAL © 1989 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PROJECT AND NOT BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
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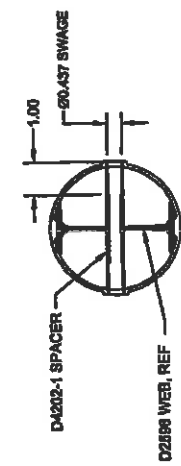


D2580-049 ASSEMBLY DETAIL

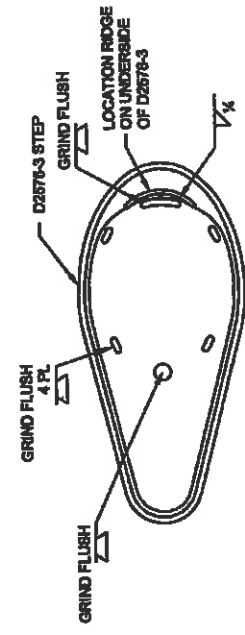
DETAIL L
SCALE 5X



SECTION M-M
SCALE 5X



DETAIL N
SCALE 5X

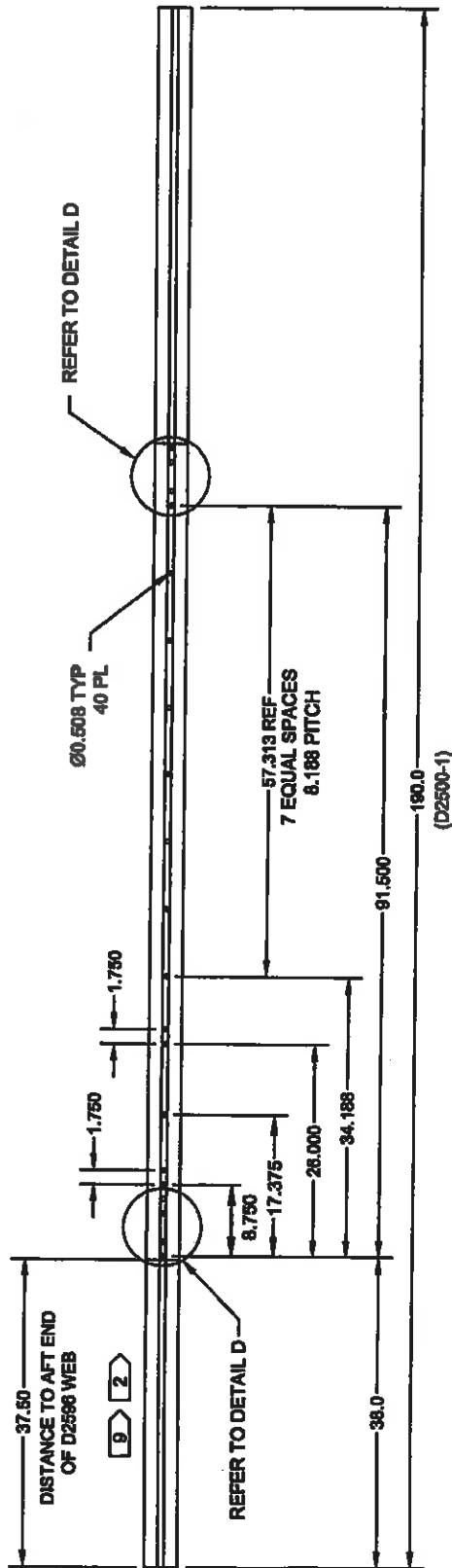


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 60,808 HOLES ONLY:
1. INSERT D4022-1 SPACER (24 PLACES)
2. SWAGE TO 60,437 X 1.00 DEEP PER QSI 002
3. TRIM GRIND FLUSH PER QSI 002

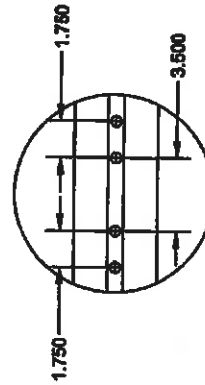
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INFG. APPR.	<i>[Signature]</i>	REV. H SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	SCALE
DE APPR.	<i>[Signature]</i>	TITLE
DATE	17.06.09	205 SKIDTUBE ASSEMBLY
		NTB

DART AEROSPACE LTD
1000 SHEPPARD AVENUE EAST, SUITE 100
HAWKESBURY, ONTARIO L6C 3K1
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TEL: 905.882.1111 FAX: 905.882.1112
WWW.DARTAEROSPACE.COM



D2550-101 TUBE



DETAIL D
SCALE 5X

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2017 JUL 05

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CHECKED		DRAWING NO. D2550
MFG. APPR.		REV. H SHEET 9 OF 9
APPROVED		TITLE 208 SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
DATE	17.06.09	208 SKIDTUBE ASSEMBLY

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PAGE 1 OF 1

Description: REPLACEMENT SKIDTUBE w/ THRU BOLT WEARPLATES

H:\Forms\Engineer\Approved Eng Online\CHGREC revB